

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 36216

Job Number:

Part Number: D3401041



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Insert

Pick:

Qty

Part number

Description

Batch

4 NAS1330C3KB116 Insert

Assemble as per Dwg D3401

Identify as D3401-041

M100712

24X44

M17524

24X44

m-h 08/03/18

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13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (+22)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 21

M-L 08/03/18

22X

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/19

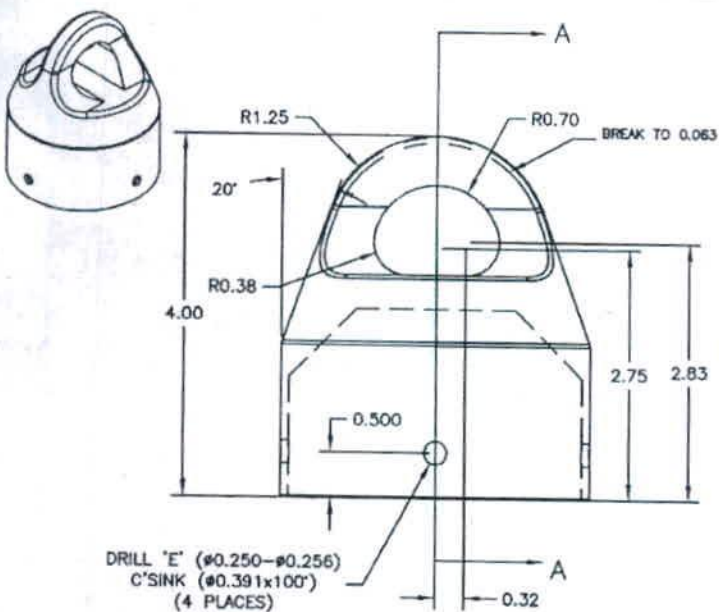
22

Job Completion

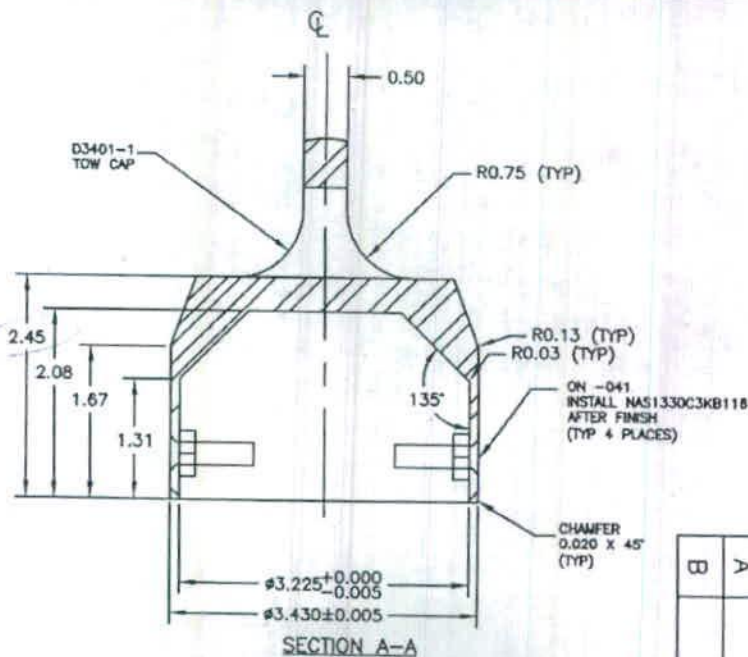


2008/3/18

22

DART

D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3



D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOT NOTICE

WORK ORDER

05-08-07 ~~11~~

DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
PH		PH		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
		D3401		SHEET 1 OF 1	
DATE		TITLE		SCALE	
05.06.09		TOW CAP		1:2	
A	05.02.24		NEW ISSUE		
B	05.06.09		CHAMFER INSIDE, REMOVE RADIUS		

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